

Work Order ID 66946

Thursday, March 03, 2011 8:45:56 AM



Page 1

Item ID: D3278-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Assembly

Start Date: 3/3/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: *11-03-3*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3278

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Rivet spacers with support as per Dwg D3278.

EP 11/03/16 (40)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

JB 11/03/16

(40)

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble support as per Dwg D3278. ☐ ***DO NOT TIGHTEN BOLTS*** ☐ Identify as D3278-041

EP 11/03/23 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

Item ID: D3278-041

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Setup Start



Revision ID:

Stop



Item Name: Support Assembly

Start Date: 3/3/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: ST471 0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

count
440

mk 11-03-23

11/3/23 J

mk
11-03-23

Dart Aerospace Ltd

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Picklist Print

Thursday, March 03, 2011 8:46:03 AM

Page 1

Work Order ID: 66946

Parent Item: D3278-041

Parent Item Name: Support Assembly



Start Date: 3/3/2011

Required Date: 3/11/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: ☐ A ☐ 04.04.19 ☐ New issue ☐ KJ/JLM ☐
IPP B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3278-1		Manufactured	No			100	Each	0.0000	1	40			
Support													
D3278-2		Manufactured	No			100	Each	15.0000	1	40			
Support													

Location Loc Qty Loc Code

CA	7	
62483	7	
GA	7	
62022	2	
65075	5	
ST048	1	
60565	1	

D3278-3		Manufactured	No			100	Each	80.0000	1	40			
Spacer													

Location Loc Qty Loc Code

GA	80	
65076	25	
66547	55	

B66247 (40x)

3/3/11/03/16



3/3/11/03/16

B66246

(40x)



3/11/03/16

25
15

W/O:		WORK ORDER CHANGES					
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Thursday, March 03, 2011 8:46:03 AM

Page 2

Work Order ID: 66946

Parent Item: D3278-041

Parent Item Name: Support Assembly

Start Date: 3/3/2011

Required Date: 3/11/2011

Start Qty: 40.00

Required Qty: 40.00

MS21042L4

Purchased

No

100

Each

4,865.000

2

80



Nut



EP 11/03/23

Location

Loc Qty

Loc Code

ST300

4865

1123143

2

115589

10

115621

20

116188

2833

116823

2000

80

AN4-13A

Purchased

No

120

Each

295.0000

2

80



Bolt



EP 11/03/23

Location

Loc Qty

Loc Code

ST357

295

116669

1

116786

294

80

AN960JD416

NAS1149D0463J

Purchased

No

120

Each

30.0000

4

160



Washer



47 M117065
(160x)

EP 11/03/23

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

D2230-1

Manufactured

No

120

Each

100.0000

2

80



Lug



EP 11/03/23

Location

Loc Qty

Loc Code

ST476

100

65270

100

17

B67389
(63x)

Thursday, March 03, 2011 8:46:04 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

Work Order ID: 66946



Parent Item: D3278-041



Parent Item Name: Support Assembly

Start Date: 3/3/2011

Required Date: 3/11/2011

Start Qty: 40.00

Required Qty: 40.00

MS20426AD3-6

Purchased

No

120

Each

4,409.000

4

160



Rivet

Ep Su/03/16

Location

Loc Qty

Loc Code

ST316

4409

105055

839

116289

3570

160

W/O:		WORK ORDER CHANGES					
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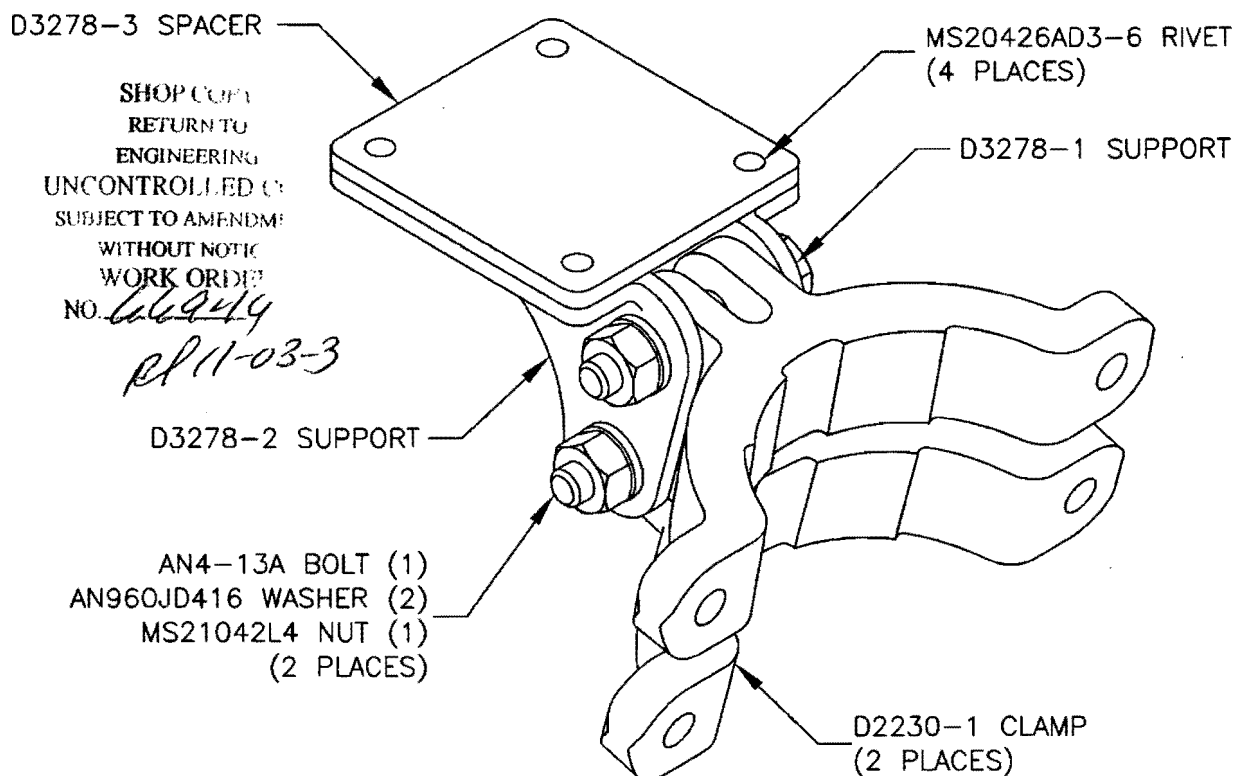
NOTE: Date & initial all entries

DART

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-08

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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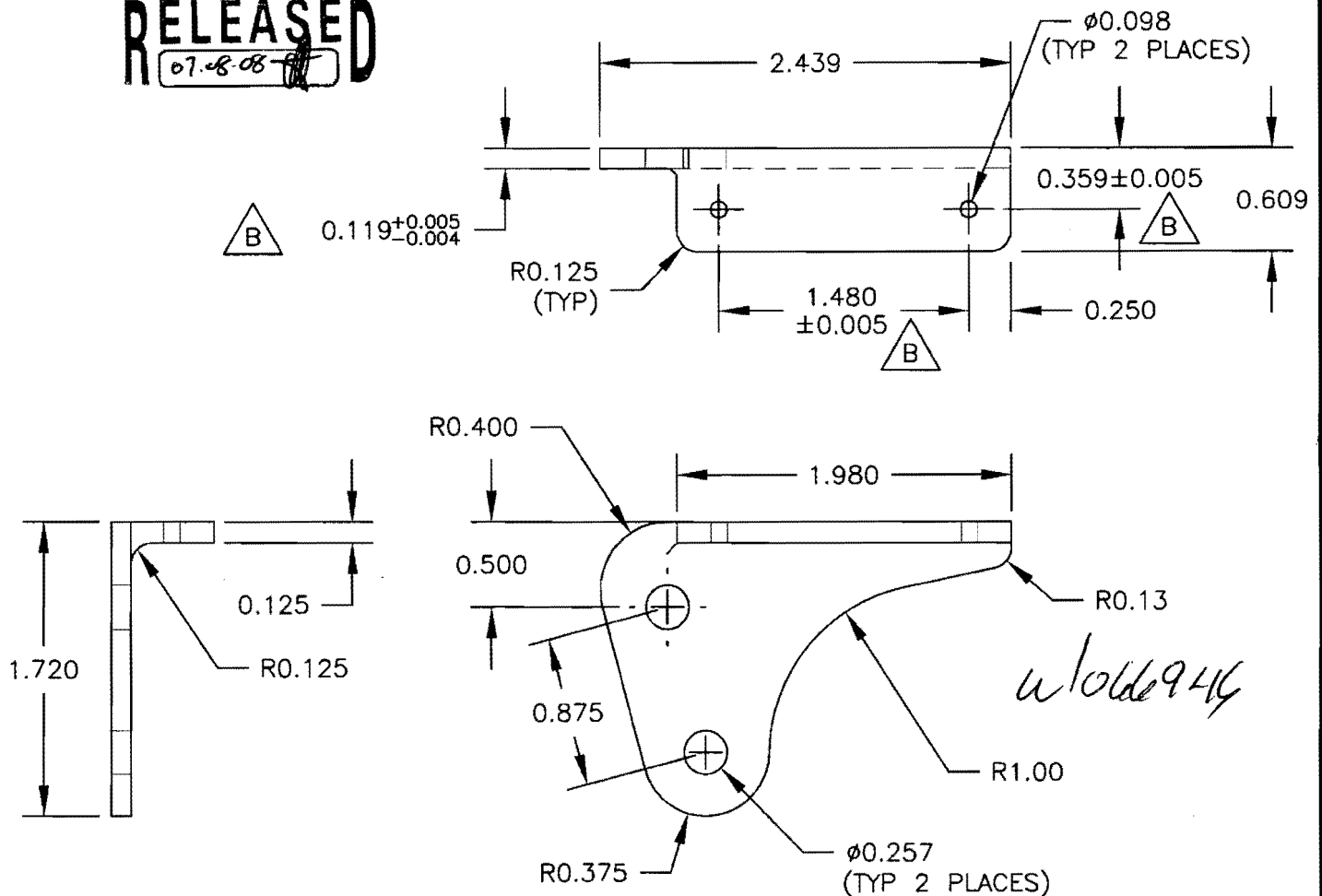
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DESIGN <i>9P1</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07-8-08



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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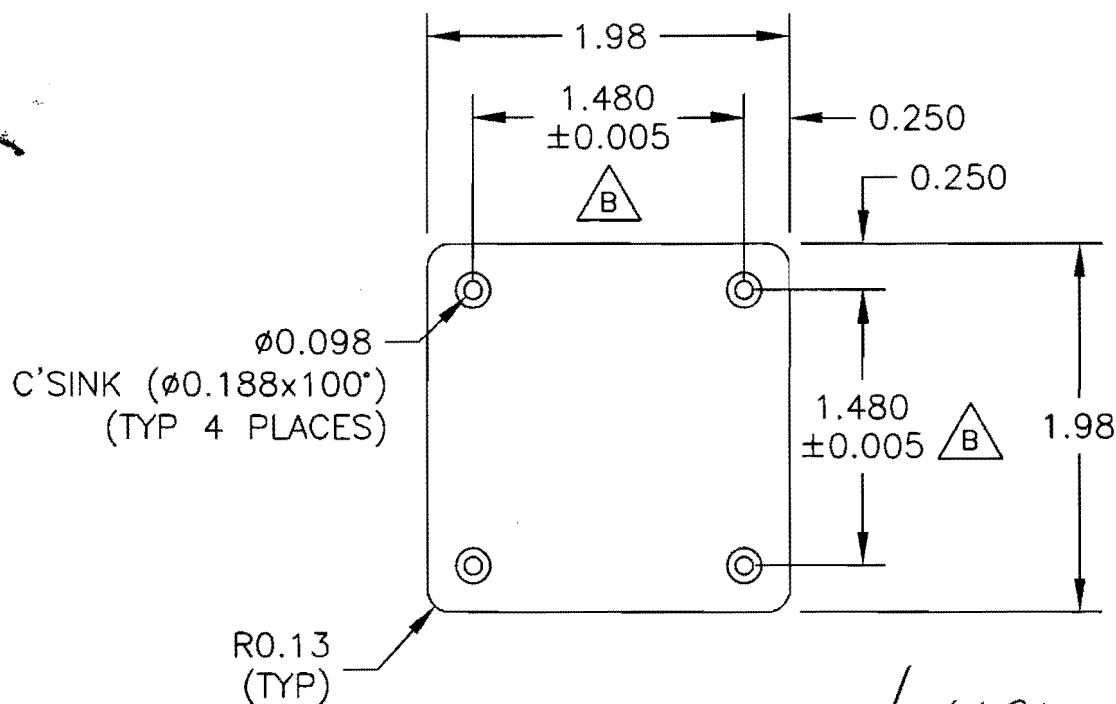
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DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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